

Split

Work Order ID 97902-2

March-01-13 1:50:01 PM

\*97902\*

Page 1

Item ID: D2362-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Support Bracket

Start Date: 3/01/13 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 3/22/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 13-03-04

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2362

Rev E1

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E 2-Deburr  
per dwg D2362

20

DAS  
25 13-3-14  
2-03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

DAS  
25 13-3-17  
2-03

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

OK 13/03/17 20

Work Order ID 97902

\*97902\*

Page 2

March-01-13 1:50:01 PM

Item ID: D2362-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Support Bracket

Start Date: 3/01/13

Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 3/22/13

Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Run Start

\*NR1\*

Stop

\*NR2\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

Small Fab

Small Fab

Small Fab

Memo

Deburr

0.00

0.00

N/A

140

\*140\*

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

0.00

150

\*150\*

QC

Quality Control

QC3- Inspect Part Finish

Memo

M125064

3200E

12-30

20X Ø M/L 13/04/09

20 Ø B49



# Work Order ID 97902

March-01-13 1:50:01 PM

\*97902\*

Page 3

Item ID: D2362-3 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Support Bracket  
 Start Date: 3/01/13 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 3/22/13 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|           |   |      |  |  |  |   |   |  |                |
|-----------|---|------|--|--|--|---|---|--|----------------|
| 160       | Small Fab   | 0.00 |  |  |  | 4 | 4 |  | FF<br>13-04-17 |
| *160*     |   |      |  |  |  |   |   |  |                |
| Small Fab | Memo  | 0.00 |  |  |  |   |   |  |                |
| Small Fab | Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362 |      |  |  |  |   |   |  |                |
|           | Batch 124297  |      |  |  |  |   |   |  |                |

|                 |   |      |  |  |  |   |  |  |  |
|-----------------|---|------|--|--|--|---|--|--|--|
| 170             | QC5- Inspect part completeness to step on W/O | 0.00 |  |  |  | 4 |  |  |  |
| *170*           |   |      |  |  |  |   |  |  |  |
| QC              | Memo  | 0.00 |  |  |  |   |  |  |  |
| Quality Control |   |      |  |  |  |   |  |  |  |

|           |                                      |      |  |  |  |    |  |  |  |
|-----------|--------------------------------------|------|--|--|--|----|--|--|--|
| 180       | Identify as per dwg & Stock Location | 0.00 |  |  |  | 4x |  |  |  |
| *180*     |                                      |      |  |  |  |    |  |  |  |
| Packaging | Memo                                 | 0.00 |  |  |  |    |  |  |  |
| Packaging |                                      |      |  |  |  |    |  |  |  |

190 QC 21 FINAL Inspection/W/O Release 13/4/17

13-04-17

# Picklist Print

March-01-13 1:50:01 PM

Page 1

Work Order ID: 97902  
Parent Item: D2362-3  
Parent Item Name: Support Bracket

Start Date: 3/01/13

Required Date: 3/22/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: G00.05.18Added inspection level 8EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2265<br>Step Bracket           |                        | Manufactured  | No          |                     |                  | 160             | Each               | 25.0000         | 1           | 20           | 20            | JFC/ 2013-03-1 |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | ST488               |                  | 25              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 44114               |                  | 25              |                    |                 |             |              |               |                |        |
| D2397-1<br>Rubber Cushion       |                        | Manufactured  | No          |                     | 97975            | 160             | Each               | 17.0000         | 1           | 20           | 4             | FF 13-04-16    |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | GA                  |                  | 17              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 72737               |                  | 1               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 91400               |                  | 16              |                    |                 |             |              |               |                |        |
| D2397-3<br>Rubber Cushion       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 16.0000         | 1           | 20           | 4             | FF 13-04-16    |        |
|                                 |                        |               |             | <u>Location</u>     | 97918            | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | GA                  |                  | 2               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 87865               |                  | 2               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | ST012               |                  | 14              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 91401               |                  | 14              |                    |                 |             |              |               |                |        |



**DART**



RELEASED  
1998.12.14 KE

| DESIGN           | DRAWN BY                      | DART AEROSPACE LTD          |
|------------------|-------------------------------|-----------------------------|
| BW               | CP                            | HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br>KE    | APPROVED<br>*                 | DRAWING NO.<br>D2362        |
| DATE<br>98.12.04 | TITLE<br>STEP SUPPORT BRACKET | REV. E<br>SHEET 1 OF 3      |
| A                | 95.02.15                      | NEW ISSUE                   |
| B                | 95.03.22                      | CHANGED RUBBER TO D2397     |
| C                | 96.01.22                      | ADD D2362-5                 |
| D                | 97.05.21                      | ADD D2362-7                 |
| E                | 98.12.04                      | REDRAWN, ADD 2397-5         |

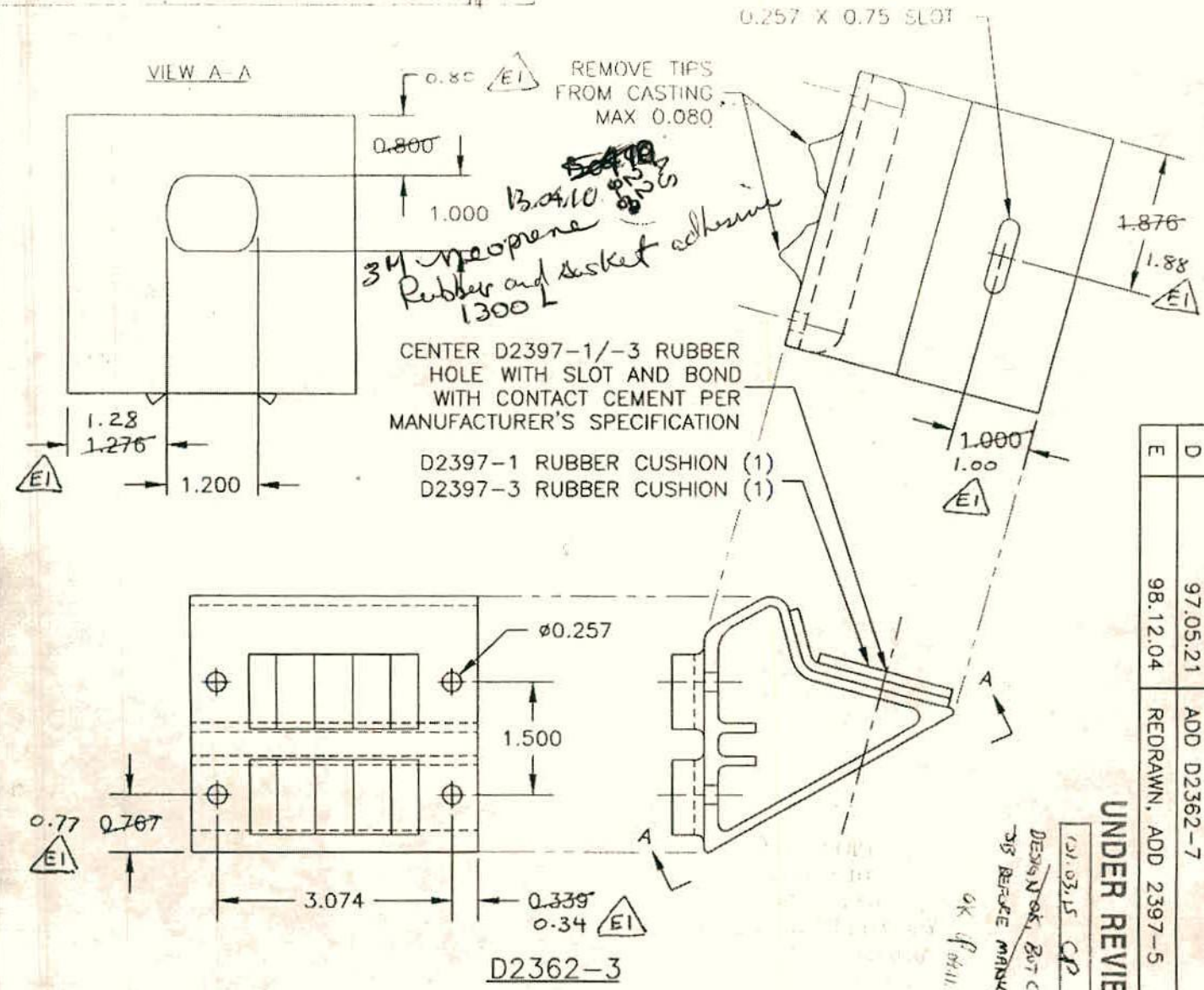
UNDER REVIEW

121.03.15 CP

DESIGN OK, BUT CHECK WITH  
D2362 MANUFACTURE

97902 MC  
13-03-04

EI 03.10.97 TOLERANCE CHANGE



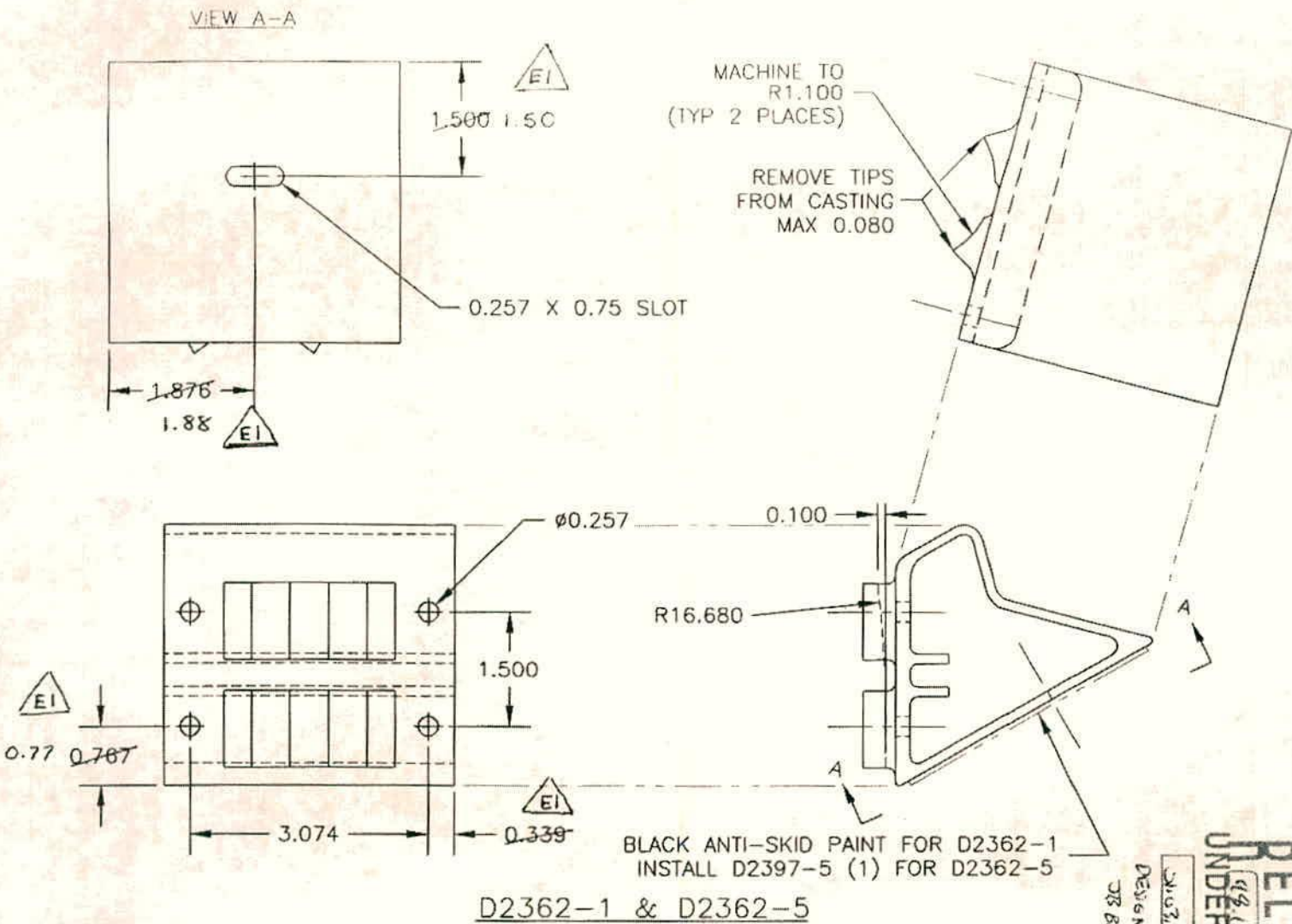
NOTES:  
MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

97902

**DART**



|         |          |          |       |                             |              |
|---------|----------|----------|-------|-----------------------------|--------------|
| DESIGN  | BW       | DRAWN BY | CP    | DART AEROSPACE LTD          | REV. E       |
| CHECKED | KE       | APPROVED | SP    | HAWKESBURY, ONTARIO, CANADA | SHEET 2 OF 3 |
| DATE    | 98.12.04 | TITLE    | D2362 | STEP SUPPORT BRACKET        | SCALE 1:2    |



**NOTES:**  
 MAKE FROM D2265  
 D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
 D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION  
 FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3  
 BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**RELEASED**  
 98.12.14  
 UNDER REVIEW  
 DESIGNER, B. J. G. H. E. L. W.  
 OR BEFORE MANUFACTURE  
 OK CP

97902

**DART**

NOT FOR CONSTRUCTION

|         |          |          |                      |   |              |
|---------|----------|----------|----------------------|---|--------------|
| DESIGN  | BMW      | DRAWN BY | CP                   | DART AEROSPACE LTD<br>HAMKESBURY, ONTARIO, CANADA | REV. E       |
| CHECKED | KE       | APPROVED | KE                   | DRAWING NO. D2362                                 | SHEET 3 OF 3 |
| DATE    | 98.12.04 | TITLE    | STEP SUPPORT BRACKET | SCALE   | 1:2          |

UNDER REVIEW

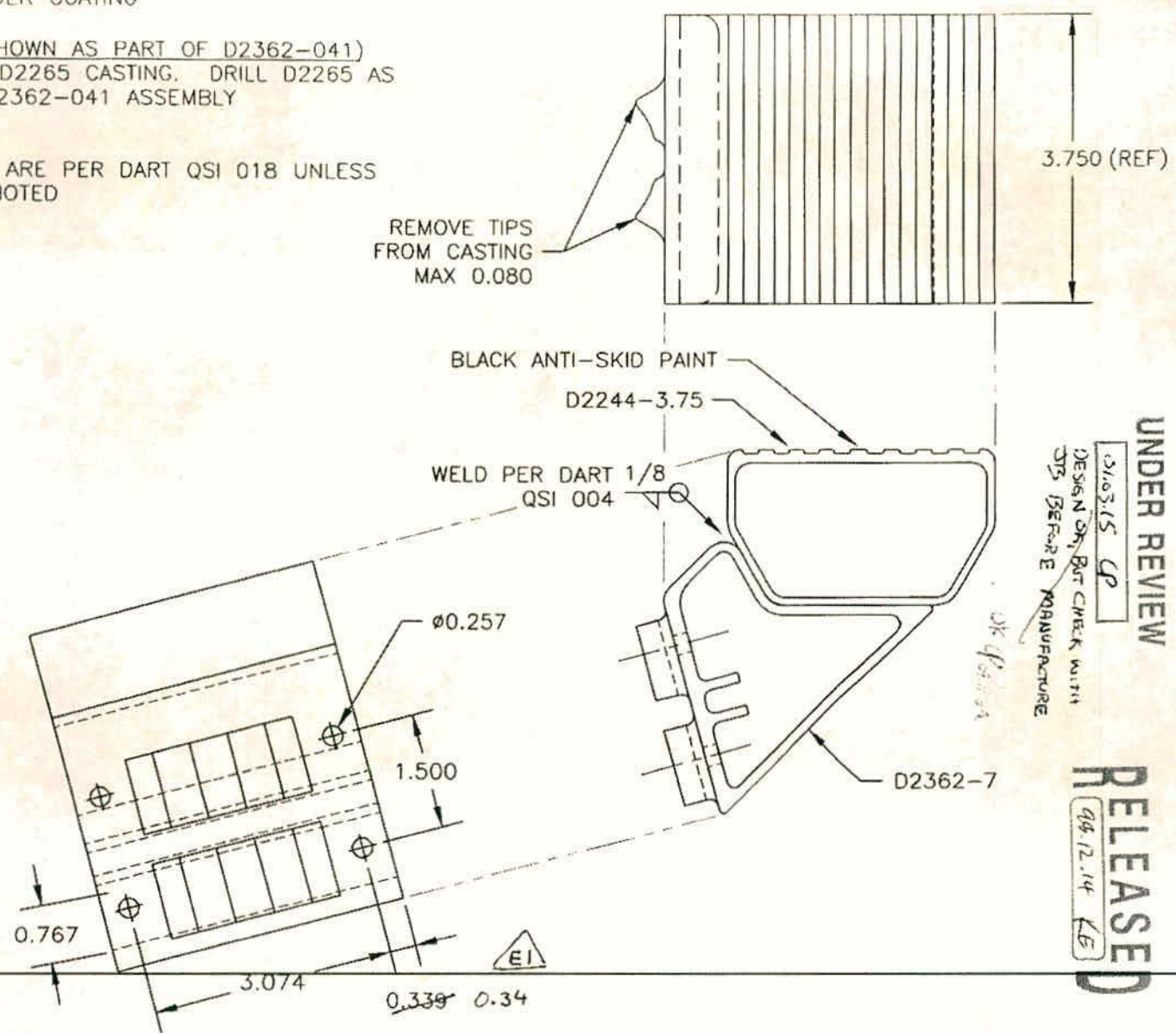
3103.15 CP  
DESIGN OK, BUT CHECK WITH  
MFG BEFORE MANUFACTURE

RELEASED  
98.12.14 KE

D2362-041 (SHOWN)  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:  
TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



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